

Claims

1. Arrangement for producing molded concrete bricks, having at least one insert that determines the contour of a molded brick, and an insert support to hold the insert in a molding machine and to press the insert against a vibrating base, characterized in that the insert support is structured as a hollow case that is rigid to resist twisting, having a base plate, a cover plate, and side walls, in the base plate and cover plate of which recesses for accommodating the insert are present, and that the insert is horizontally supported by the edges of the recesses and vertically supported on the base plate and/or the cover plate.
2. Arrangement according to claim 1, characterized in that the cover plate and/or the base plate are part of a bent piece of sheet metal, having at least two side wall parts that face the other plate, in each instance.
3. Arrangement according to claim 1 or 2, characterized in that the cover plate and the base plate are, in each instance, the center part of one of two pieces of sheet metal bent in U shape, and engage into one another with the openings of the U shapes facing one another, rotated by 90°.

4. Arrangement according to one of claims 1 to 3, characterized in that spacer elements are inserted within the case, at a distance from the insert, between the cover plate and the base plate.
5. Arrangement according to claim 4, characterized in that the spacer elements are supported on the inner surfaces of the cover plate and the base plate, and project into openings in the base plate and the cover plate with projections.
6. Arrangement according to claim 4 or 5, characterized in that the spacer elements are welded to the base plate and/or the cover plate.
7. Arrangement according to one of claims 1 to 6, characterized in that the insert supports itself on the inner surface of the base plate and/or the cover plate.
8. Arrangement according to one of claims 1 to 7, characterized in that the insert is pushed through the recesses of one of the plates from the outside, until it comes to a stop on a first one of the two plates, and is attached to the second of the two plates

9. Arrangement according to one of claims 1 to 8, characterized in that the insert is welded to the base plate and/or the cover plate.
10. Arrangement according to one of claims 1 to 8, characterized in that the insert is releasably inserted into the case, in destruction-free manner.
11. Arrangement according to one of claims 1 to 10, characterized in that the insert projects beyond the base plate and/or the cover plate.
12. Arrangement according to claim 11, characterized in that the insert projects beyond the cover plate and that its upper edge lies essentially in a plane with the upper surface of a sheet-metal cover arrangement.
13. Arrangement according to claim 12, characterized in that the part of the insert that projects beyond the cover plate has an undercut and that an edge of the sheet-metal cover engages in the undercut.

14. Arrangement according to one of claims 1 to 13, characterized in that elastic damping material is inserted between the insert support and the insert.
15. Arrangement according to one of claims 1 to 4, characterized in that the insert has a slot for accommodating a core holder.
16. Arrangement according to claim 15, characterized in that the slot and the core holder continue into the cover plate and that the core holder is supported downward in the slot of the insert and upward by means of a sheet-metal cover arrangement that is attached onto the cover plate.
17. Arrangement according to one of claims 1 to 16, characterized in that at least two opposite side walls have a relief for holding the case in a corresponding counter-relief of a molding frame.
18. Arrangement according to claim 17, characterized in that the relief comprises a groove milled into a side wall.
19. Arrangement according to claim 17 or 18, characterized in that the relief is formed by multiple bending of sheet-metal segments that form the side walls.

20. Arrangement according to one of claims 17 to 19, characterized in that the relief of the case and the counter-relief of the molding frame overlap horizontally and that damping means are inserted between vertically opposite surfaces of the relief and the counter-relief.
21. Arrangement according to one of claims 1 to 20, characterized in that bracing elements rest against side walls of the case from the inside, and brace them against counter-surfaces of a flange arrangement from the outside, with a positive lock.
22. Arrangement according to one of claims 1 to 16, characterized in that flange rails are firmly connected with the insert support, on opposite side walls, for saving into the molding machine.
23. Arrangement according to claim 22, characterized in that junction plates are connected with the side walls as well as the cover plate and/or the base plate, in the interior of the insert support.